

FF. Pucher

# Work Order ID 73824

Friday, September 16, 2011 11:30:41 AM



Page 1

Item ID: D2885

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 9/16/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 200.00



Customer:

Reference:

Approvals:

Process Plan: W

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2885

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2885

☐ Dwg Rev: B

☐ Prog Rev: B

☐ 2-

Deburr if necessary

B11-9-26



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-9-26

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/10/27

x240

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D2885	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Saddle Spacer					
Start Date: 9/16/2011	Start Qty: 200.00		Cust Item ID:		
Required Date: 10/14/2011	Req'd Qty: 200.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				240 counted	6	11/09/27	
140  QC Quality Control	QC3- Inspect part completeness to step on W/O acs Memo	0.00  0.00				240.		BR 11-9-27.	
150  Packaging Packaging	Identify as per dwg & Stock Location <del>505</del> Memo	0.00  0.00						11-09-27.	

W/O:		WORK ORDER CHANGES					
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**Work Order ID 73824**

Friday, September 16, 2011 11:30:41 AM



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Item ID: D2885

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 9/16/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 200.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/28

MK 11-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, September 16, 2011 11:30:38 AM

Page 1

Work Order ID: 73824



Parent Item: D2885

Parent Item Name: Saddle Spacer

Start Date: 9/16/2011

Required Date: 10/14/2011

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP A□99.10.12□New Issue□EC□  
IPP Rev:B Now 6060-T6 06-06-23 JLM  
IPP Rev:C waterjet 06-07-23 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 		Purchased	No			100	sf	116.3000	0.0257	5.410526	8.		
6061-T6 .080 Sheet											1311-9-26		

Location

Loc Qty

Loc Code

MAT021

116.3

116268

9.5

117285

106.8

119009

119009

340

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	73824
<b>Description:</b> Saddle Spacer		<b>Part Number:</b>	D2885
<b>Inspection Dwg:</b> D2885 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	+/-0.030	.430	x		V 1B02	
0.443	+/-0.010	.444	x		V	
Ø0.257	+0.006/-0.001	.260	2		V	
R0.30	+/-0.030	.30	x		R.G.	
0.679	+/-0.010	.674	x		V	
R0.40	+/-0.030	.40	x		R.G.	
0.250	+0.030/-0.000	.250	x		V	
0.672	+/-0.010	.669	x		V	
0.521	+/-0.010	.523	x		V	
1.340	+/-0.010	1.340	x		V	
2.681	+/-0.010	2.688	x		V	
3.71	+/-0.030	3.71	x		V	
R0.38	+/-0.030	.38	x		R.G.	
0.528	+/-0.010	.529	x		V	
0.080°	+/-0.5°	.080°	x		V	

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-9-26	<b>Date:</b> 11/09/27	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	06.08.30	New Issue	KJ/JLM	[Signature]

W/O:		WORK ORDER CHANGES					
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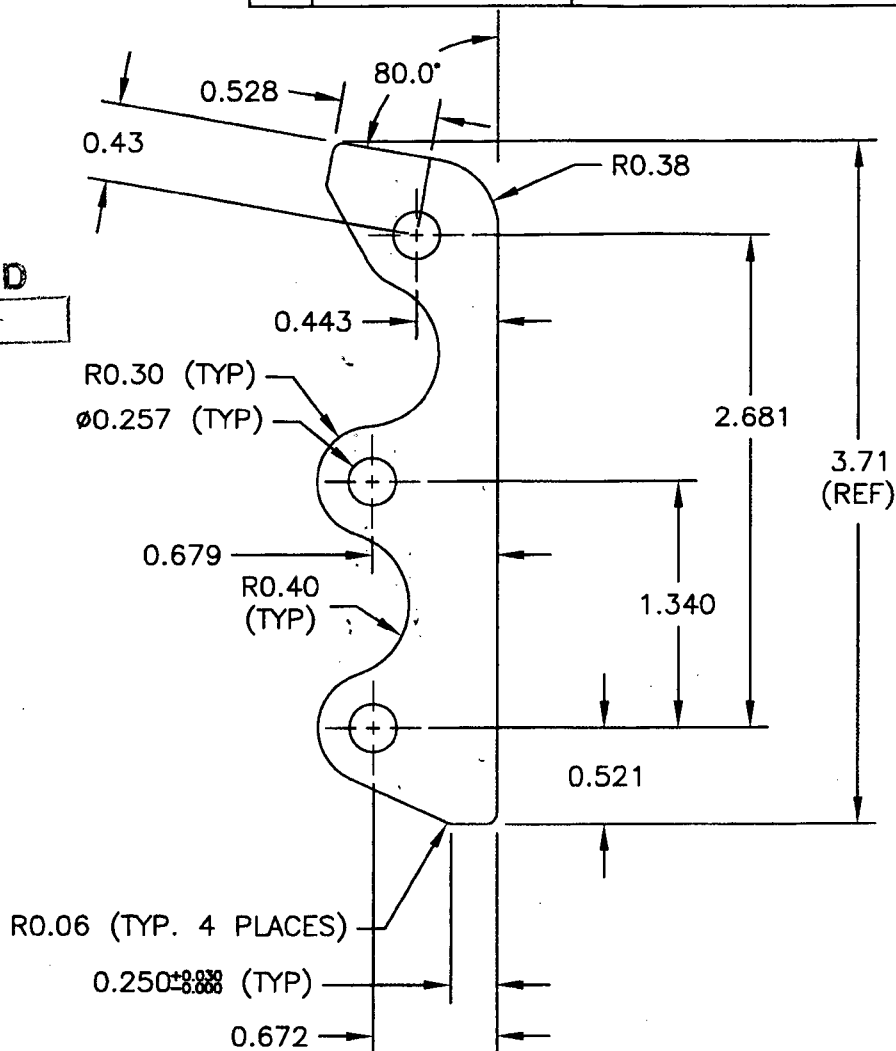
**NOTE:** Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2885	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.04.01	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED  
*cl. cl. 20*

73824

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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